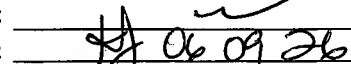
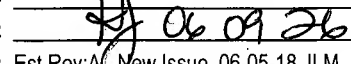


Date: Tuesday, 9/26/2006 2:41:06 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : STUB COVER
Job Number : 28725	
Estimate Number : 12415	
P.O. Number : N/A	Part Number : D34941
This Issue : 9/26/2006 S.O. No. : N/A	Drawing Number : D3494 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : LARGE FAB ASSY	Drawing Revision : A
Previous Run : 27233	Material : N/A
Written By : 	Due Date : 10/3/2006 Qty: 8 Um: Each
Checked & Approved By : 	
Comment : Est Rev: A New Issue 06-05-18 JLM	

Additional Product


Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	M304S16GA	304/316 .063 Sheet
-----	-----------	--------------------




Comment: Qty.: 0.6972 sf(s)/Unit Total : 5.5776 sf(s)
 304/316 .063 Sheet
 (M304S16GA)
 Batch: M101873  06 09 27

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET
 1-Cut as per Dwg D3494
 Dwg Rev: A
 Prog Rev: A

 06 09 27

⑧

2-Deburr if necessary

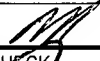
SAP 06/09/28

⑧

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

 06 09 27

⑧

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

06-09-27

⑧

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1
 Form as per Dwg D3494

SJS 06/10/11

6
PTD

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/10/11
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>06/10/11</u>	<u>5</u>	<u>2 piece were scrap.</u>	<u>[Signature]</u> <u>06/10/11</u> <u>2</u>	<u>Scrap + destroy</u>	<u>SB</u> <u>06/10/11</u>	<u>[Signature]</u> <u>06-10-11</u>	<u>[Signature]</u> <u>06-10-11</u> <u>2</u>	<u>[Signature]</u> <u>06-10-11</u>

NOTE: Date & initial all entries

Date: Tuesday, 9/26/2006 2:41:07 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STUB COVER

Job Number: 28725

Part Number: D34941

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7-10-11 (6)

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld as per Dwg D3494

A/R SS ROD Batch: *M101744*

AA 06/10/11 (6)

8.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

PD 06-10-11 (6)

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

FC 06 10 11 (6)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

PC 6/14/12 (6)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *5783*

PC 4/10/12 (6)

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

SP 06/10/12 (6)

Job Completion



W 10-10-12

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

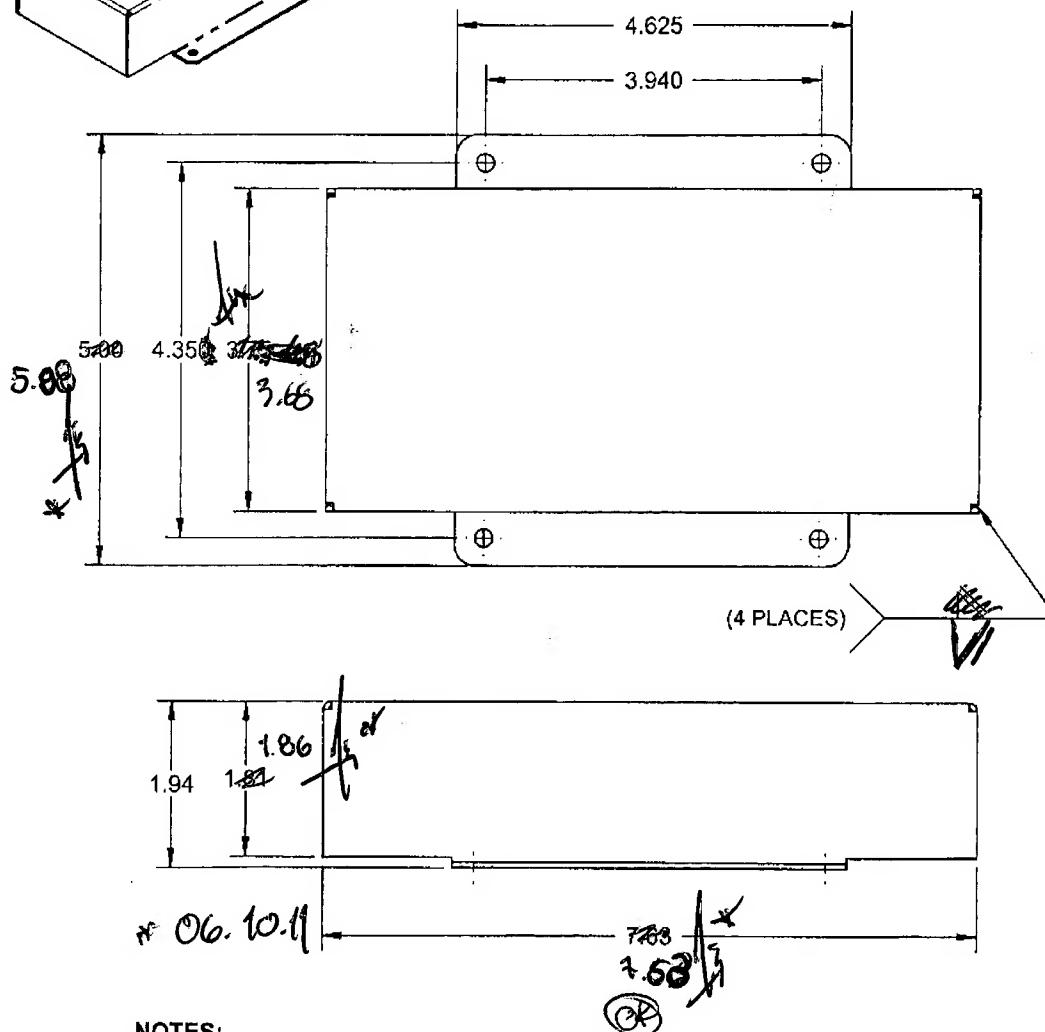
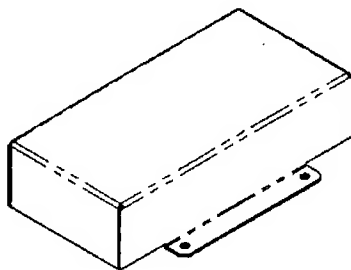
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN MB	DRAWN BY MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3494	REV. A SHEET 1 OF 2
DATE 06.01.16	TITLE STUB COVER		SCALE 1:2
A	06.01.16	NEW ISSUE	

**NOTES:**

- 1) MATERIAL: MAKE FROM D3494-1F
- 2) WELD PER DART QSI 004
- 3) FINISH: POWDER COAT PAINT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

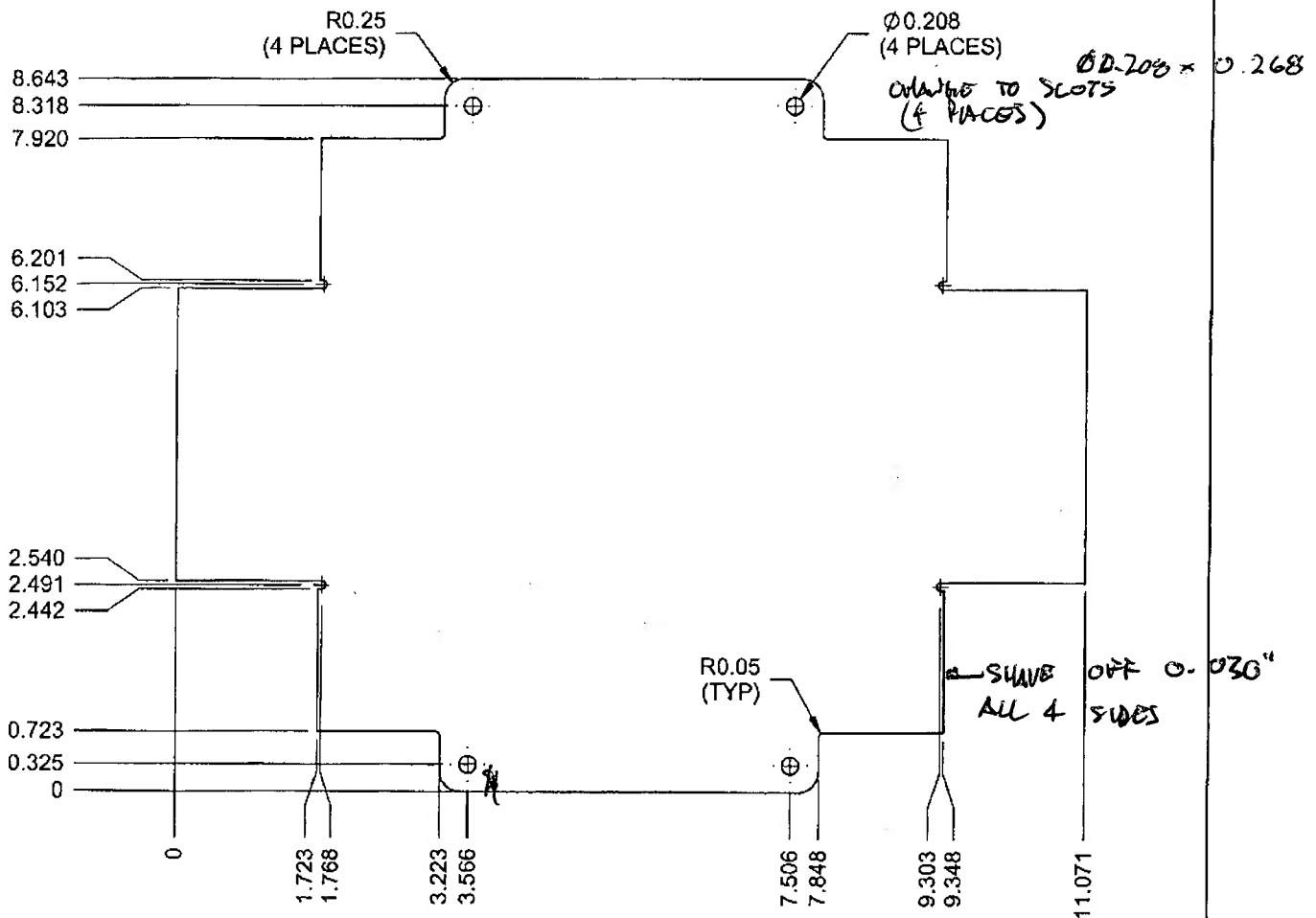
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NO. 28725

DART

DESIGN MB	DRAWN BY MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3494	REV. A SHEET 2 OF 2
DATE 06.01.16	TITLE STUB COVER		SCALE 1:2

**D3494-1F STUB COVER FLAT PATTERN****NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET (0.060 THICK) PER MIL-S-5019 (ANNEALED TYPE 2B FINISH) (REF. DART SPEC. M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

06.01.16 SHOT COPY
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WORK ORDER
NO. _____

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